



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4016-1
Job Sheet 167095



Part No: D4016-1

Job Qty: 100 ea

Part Name: Hinge Half, Base



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 10/31/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Ship Via:

DWG Rev. B ✓

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	100 Ea		10/26/17	0.00	0.00	Start Up Machining	FM
100	Bandsaw	100 pcs		10/27/17	0.00	6.50	Bandsaw1	FM
110	CNC Vertical Machining	100 pcs		10/31/17	0.03	42.92	HAAS 1	FM
130	QC	100 pcs		10/31/17	0.00	0.00	QC8	FK-17-11-15
160	Packaging	100 pcs		10/31/17	0.00	0.00	Packaging3	WA004 NOV 16 2017
170	QC21-SA	100 Ea		10/31/17	0.00	0.00	QC21	17/11/16

Part Op 100 - CUT BLANK 1.00" LONG

Descriptions: 110 - MACHINE AS PER FOLIO FA869 AND DWG

160 - LOCATION: WA004

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304B1.000X1.000	8	12	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hinge Half, Base	0.875Inches ± 0.010	0.885 0.865		
2	Hinge Half, Base	0.250Inches ± 0.030	0.280 0.220		
3	Hinge Half, Base	0.380Inches + 0.030 - 0.000	0.410 0.380		
4	Hinge Half, Base	0.030Inches ± 0.030	0.060 0.000	Radius	
5	Hinge Half, Base	0.130Inches ± 0.030	0.160 0.100		
6	Hinge Half, Base	0.880Inches ± 0.030	0.910 0.850		
7	Hinge Half, Base	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter	
8	Hinge Half, Base	0.380Inches ± 0.030	0.410 0.350	Radius	
9	Hinge Half, Base	0.500Inches ± 0.030	0.530 0.470		
10	Hinge Half, Base	0.750Inches ± 0.030	0.780		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

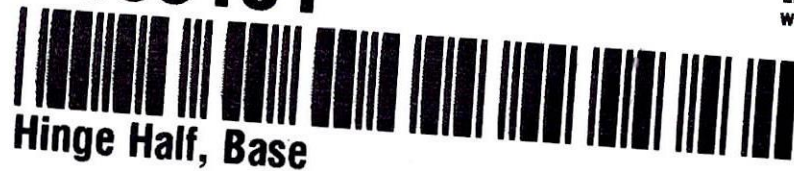
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
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Description Work Order Deviation:

DART
AEROSPACE
S009181



Hinge Half, Base

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

PART NO:
Revision:
Operation:
Change No:

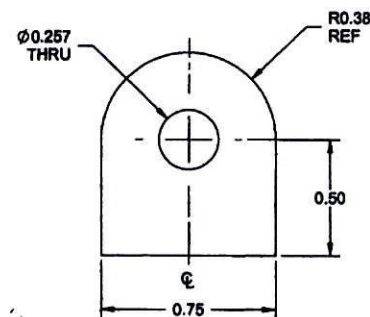
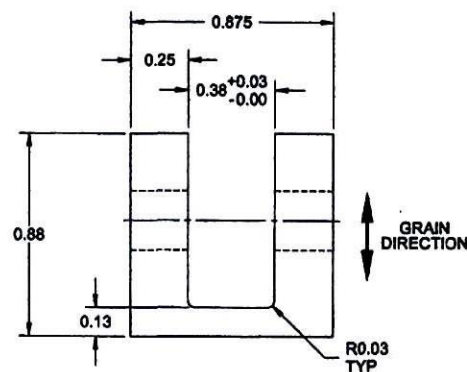
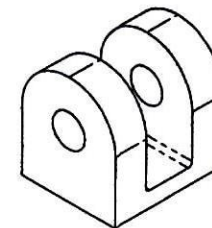
D4016-1

Start up Operation

Mfg Date: 11/13/17
Job No: 167095

Root Cause			
Environment ☐	No Re-verification ☐		
Design ☐	Operator ☐		
Doc/Data ☐	Offset/Setup ☐		
Equip/Tooling ☐	Supplier ☐		
Handling/Pre ☐	Training ☐		
Material ☐	Use for Testing ☐		
Internal Transport ☐	Poor Information ☐		
Tribal Knowledge ☐	Rushing ☐		
LOA ☐	Product Improvement ☐		
Substation ☐	Process Improvement ☐		
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐		
OTHER : _____			

- ☐ Positioned Wrong
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Drawing
- ☐ Finish
- ☐ Misread
- ☐ Turning Sequence



D4016-1 HINGE HALF, BASE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.09 lbs

RELEASED
2017-03-22
ECN 17-535

APPROVED

B	ADDED -7; REFORMAT PER CURRENT STANDARD	RF	17.02.09
A	NEW ISSUE	JPH	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	WK	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4016	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BASKET HINGE	NTS
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